

Date: Wednesday, 11/04/2007 8:57:10 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D3537-1		
Job Number	: 31741					
Estimate Number	: 10804					
P.O. Number	:			Part Number	: D35371	
This Issue	: 11/04/2007		S.O. No. :	Drawing Number	: CUSTOM-H/D WELDS	
Prsh Rev.	: NC			Project Number	:	
First Issue	: / /		Type :	Drawing Revision	:	
Previous Run	: 00015			Material	:	
Written By				Due Date	: 13/04/2007	
Checked & Approved By	<u>Linda Lacelle</u>			Qty:	18	Um: Each
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode	Barcode	Comments
1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			(18X)
		Comment: HAND FINISHING RESOURCE #1 PULL FROM STOCK 18 X D3537-1 B <u>31741 B30757</u>			
		REMOVE PAINT WITH PAINT STRIPPER			M.L 07/04/11
2.0	D35371	WEARPAD			(18X)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s) WEARPAD			M.L 07/04/11
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1			(18X)
		Comment: LARGE FABRICATION RESOURCE 1 CLEAN PROPERLY WITH A WIRE BRUSH			M.L 07/04/11
4.0	QC5	INSPECT WORK TO CURRENT STEP			(18X)
		Comment: INSPECT WORK TO CURRENT STEP			M.L 07/04/11
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1			
		Comment: LARGE FABRICATION RESOURCE 1			
		WELD AS PER DRWG D3537 - MARKED UP BY SERGE HEAVY DUTY HARD FACING A7560/3-2 B <u>102755</u>			FC 07 04 R (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 8:57:10 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3537-1

Job Number: 31741

Part Number: D35371

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5/9	WELD INSPECTION
	Comment: WELD INSPECTION	M 07/04/12 (18)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING REPAINT GREY SANTEX PER QSI 005	M 19720 (18X)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	U 37-04.12
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 RESTOCK USING NEW B/N USE FOR TUBES - 30967A & 30968A ONLY	SL 30967A 07-04-13 968A
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	U 87-04.13

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

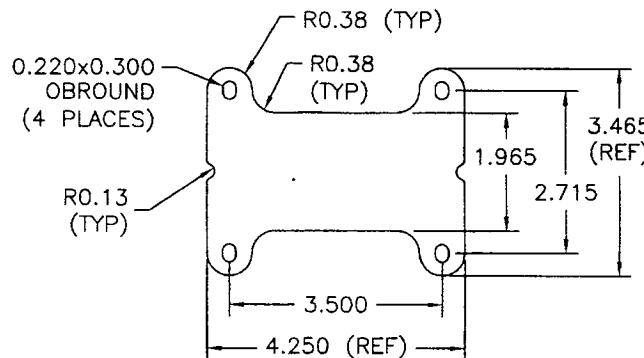
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

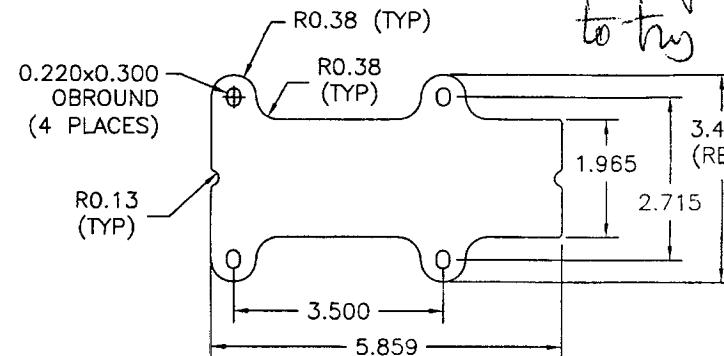
NOTE: Date & initial all entries

30967A
30968A

D3537-1F FLAT PATTERN



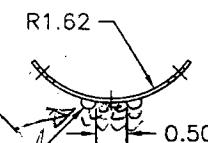
D3537-3F FLAT PATTERN



*Additional welds
are for customer
to try and give
I VS a feed back*

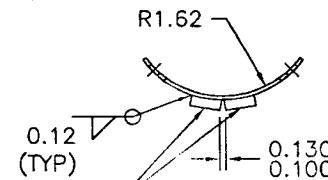
*AS Per Bill
Beckett,
N/A*

SECTION A-A

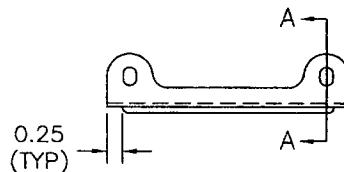


2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B



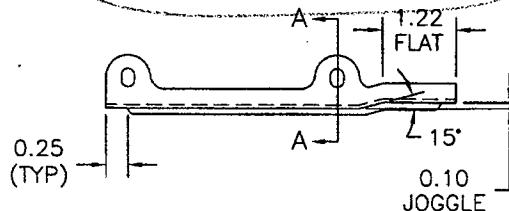
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



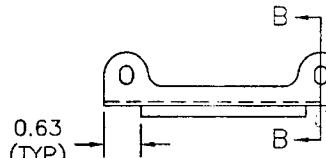
RELEASED

07-21-12

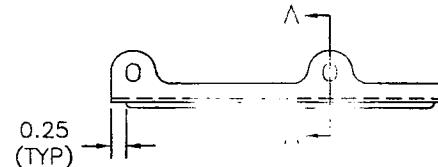
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

A	06.11.06	NEW ISSUE
DESIGN	DRAWN	
CB	C	
CHECKED	APPROVED	DRAWING
PH	H	D3537
DATE	TITLE	SCALE
06.11.06	WEARPAD	1:2

JASPACE USA, INC.
PORT HADLOCK, WA
REV. A
SHEET 1 OF 1